

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
7 July 2005 (07.07.2005)

PCT

(10) International Publication Number
WO 2005/061748 A1

- (51) International Patent Classification⁷: **C22C 38/00** 10-2004-0071395
7 September 2004 (07.09.2004) KR
- (21) International Application Number: 10-2004-0071705
PCT/KR2004/003375 8 September 2004 (08.09.2004) KR
10-2004-0084297 21 October 2004 (21.10.2004) KR
- (22) International Filing Date:
21 December 2004 (21.12.2004)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
10-2003-0095393 23 December 2003 (23.12.2003) KR
10-2003-0095395 23 December 2003 (23.12.2003) KR
10-2003-0095394 23 December 2003 (23.12.2003) KR
10-2003-0098745 23 December 2003 (23.12.2003) KR
10-2003-0098744 29 December 2003 (29.12.2003) KR
10-2003-0099437 29 December 2003 (29.12.2003) KR
10-2003-0099435 29 December 2003 (29.12.2003) KR
10-2003-0098743 29 December 2003 (29.12.2003) KR
10-2003-0098746 29 December 2003 (29.12.2003) KR
10-2003-0099350 29 December 2003 (29.12.2003) KR
10-2003-0099351 29 December 2003 (29.12.2003) KR
10-2003-0099463 30 December 2003 (30.12.2003) KR
10-2003-0099462 30 December 2003 (30.12.2003) KR
10-2003-0099464 30 December 2003 (30.12.2003) KR
10-2003-0099461 30 December 2003 (30.12.2003) KR
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- (81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.
- (84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

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(54) Title: **BAKE-HARDENABLE COLD ROLLED STEEL SHEET HAVING EXCELLENT FORMABILITY, AND METHOD OF MANUFACTURING THE SAME**

(57) Abstract: A bake-hardenable cold rolled steel sheet, and a method of manufacturing the same, designed to have bake hardenability and excellent formability suitable for automobile bodies, and the like. The steel sheet comprises 0.003 ~ 0.005 % C, 0.003 ~ 0.03 % S, 0.01 ~ 0.1 % Al, 0.02 % or less N, 0.2 % or less P, 0.03 ~ 0.2 % Mn and/or 0.005 ~ 0.2 % Cu, and the balance of Fe and other unavoidable impurities in terms of weight%. When it comprises one of Mn and Cu, the composition of Mn, Cu, and S satisfies one of relationships: $0.58 \cdot \text{Mn}/\text{S} \leq 10$ and $1 \leq 0.5 \cdot \text{Cu}/\text{S} \leq 10$. When it comprises both Mn and Cu, the composition satisfies the relationships: $\text{Mn} + \text{Cu} \leq 0.3$ and $2 \leq 0.5 \cdot (\text{Mn} + \text{Cu})/\text{S} \leq 20$. MnS, CuS, and (Mn, Cu)S precipitates have an average size of 0.2 μm or less. The steel sheets allow the content of solid solution to be controlled by fine MnS, CuS, (Mn, Cu)S precipitates, providing improved bake hardenability, formability, yield strength, and yield strength-ductility balance.



WO 2005/061748 A1



Published:

— with international search report

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